

# Work Order ID 95519

Thursday, January 10, 2013 1:46:29 PM

**\*95519\***

Page 1

Item ID: D4464-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fuel Tank Assembly

Stop **\*NS2\***

Start Date: 1/10/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: *MFC*

Date: *13-1-10*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4464

D

100

Weld per dwg A/R Aluminum rod Batch: *122358* 0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

\*\*\*PURGE INSIDE OF TANK\*\*\*

**Achtung!**  
Vor Einbau Sicherheitsstift herausnehmen  
**Attention,**  
remove safety pin before installation  
**Atenção!**  
Remova o pino de segurança antes de montar

*1* *φ* *13.01.14*

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Revision ID:

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Item Name: Fuel Tank Assembly

Start Date: 1/10/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00


**\*110\***

QC

Memo

0.00

Quality Control

1 0 13-0-15 

120

Weld per dwg A/R Aluminum rod Batch: *122324* 0.00  
*123528*

0.00

**\*120\***

Large Fab

Memo

0.00

Large Fab

1-Weld top D4463-1 using DT9811 and DT9810

\*\*\*PURGE INSIDE OF TANK\*\*\*

1 0 *13-0-22*

123

QC5- Inspect part completeness to step on W/O 0.00

0.00

**\*123\***

QC

Memo

0.00

Quality Control

\*\*\*Pressure Test as per dwg D4464\*\*\*

*DAS 15 13-1-23*

1

**Work Order ID 95519**

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Item ID: D4464-041

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*140\***

QC

Memo

0.00

Quality Control

1 0 13-01-22



150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

1 NG 13-01-22

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

1 0 13-02-11





# Work Order ID 95519

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Item ID: D4464-041

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Fuel Tank Assembly

Stop \*NS2\*

Start Date: 1/10/2013 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

170

0.00

\*170\*

Powdercoat

Memo

0.00

Powder Coating

\*\*\*Mask prior to powdercoat\*\*\*

11/18/38

POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3

Start Time: 1:30

Oven Temperature: 320

Finish Time: 2:00

1 of 13-2-11

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

12 of 13/02/14

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Item ID: D4464-041

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Fuel Tank Assembly

Stop \*NS2\*

Start Date: 1/10/2013 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190                            |   | 0.00                 |         |        |              |               |               |                  |                |
| *190*                          |   |                      |         |        |              |               |               |                  |                |
| Small Fab                      |   |                      |         |        |              |               |               |                  |                |
| Small Fab                      |   |                      |         |        |              |               |               |                  |                |
|                                | Memo  | 0.00                 |         |        |              |               |               |                  |                |
|                                | 1- Mask off area, where access cover is applied   |                      |         |        |              |               |               |                  |                |
|                                | 2- Abrade surface with red scotch brite   |                      |         |        |              |               |               |                  |                |
|                                | 3- Wipe with clean cloth and wash and wipe  |                      |         |        |              |               |               |                  |                |
|                                | 4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890 |                      |         |        |              |               |               |                  |                |
|                                | A/R proseal 890 Batch: M124028  |                      |         |        |              |               |               |                  |                |
| 200                            |   |                      |         |        |              |               |               |                  |                |
| *200*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             |   |                      |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
|                                | QC5- Inspect part completeness to step on W/O   | 0.00                 |         |        |              |               |               |                  |                |
|                                | Memo  | 0.00                 |         |        |              |               |               |                  |                |

12

SP 3/02/19

P+O

DAS  
15  
8-03

13225

Dart Aerospace Ltd

| W/O: 95519 |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|            |      |                    |    |      |     |                                     |                          |
|            |      |                    |    |      |     |                                     |                          |

Part No: D4464-041 PAR #:          Fault Category: 2m Tab NCR: Yes ☒ No ☐ DQA:    Date: 13/03/11  
 Resolution:          Disposition: Rework QA: N/C Closed:    Date: 13/3/4

| NCR: 13-2362 |      | WORK ORDER NON-CONFORMANCE (NCR)                  |                             |   |  |   |   |   |
|--------------|------|---|-----------------------------|---|--|---|---|---|
| DATE         | STEP | Description of NC<br>Section A                    | Corrective Action Section B |   |  | Verification<br>Section C                 | Approval<br>Chief Eng                     | Approval<br>QC Inspector                  |
|              |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng                     | Sign &<br>Date                             |   |   |   |
| 13-02-22     | 190  | Scratch on top panel during Ass'y. Employee error | <u>W</u><br><u>13/02/25</u> | Sand out scratch and re-paint<br><br>As per QSI 005 | <u>DAS</u><br><u>05</u><br><u>13-02-22</u> | <u>DAS</u><br><u>18</u><br><u>13/2/25</u> | <u>DAS</u><br><u>29</u><br><u>13/2/25</u> | <u>DAS</u><br><u>29</u><br><u>13/2/25</u> |
|              |      |   |                             |   |  |   |   |   |
|              |      |   |                             |   |  |   |   |   |

NOTE: Date & initial all entries

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Revision ID:

Item Name: Fuel Tank Assembly

Stop **\*NS2\***

Start Date: 1/10/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Memo

0.00

Quality Control

Pick Kit

0.06

13/2/25

MLJ 13-02-25

1302-12/10

13-02-25



# Picklist Print

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER  
DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3997-5<br>Placard              |                        | Manufactured  | No          |                     |                  | 190             | Each               | 94.0000        | 2           | 2            | ✓             |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|                                 |                        |               |             | ST243               |                  | 94              |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 72611               |                  | 75              |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 81028               |                  | 4               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 83650               |                  | 6               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 87530               |                  | 9               |                    | 87530          |             |              |               |                |        |
| D3997-11<br>Placard             |                        | Manufactured  | No          |                     |                  | 190             | Each               | 8.0000         | 1           | 1            | ✓             |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|                                 |                        |               |             | Return2012          |                  | 1               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 80308               |                  | 1               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | ST243               |                  | 7               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 82957               |                  | 7               |                    | 82957          |             |              |               |                |        |
| D3997-17<br>Placard             |                        | Manufactured  | No          |                     |                  | 190             | Each               | 10.0000        | 1           | 1            | ✓             |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|                                 |                        |               |             | ST243               |                  | 10              |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 82958               |                  | 10              |                    | 82958          |             |              |               |                |        |
| D3997-29<br>Placard             |                        | Manufactured  | No          |                     |                  | 190             | Each               | 9.0000         | 1           | 1            | ✓             |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  | <u>Loc Code</u>    |                |             |              |               |                |        |
|                                 |                        |               |             | ST243               |                  | 9               |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 80845               |                  | 9               |                    | 80845          |             |              |               |                |        |

9

JB

JB

JB

JB

13-02-12

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |   |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|---|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermocforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermocforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |   |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |   |                                    |  |                                |                                    |                                    |                                   |  |
| Thermocforming <input type="checkbox"/>                      | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |   |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |   |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Misleading                      |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |

# Picklist Print

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

D3997-43 Manufactured No 190 Each 9.0000 1 1 ✓ JB 13-02-12  
Placard

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST243    | 9       |          |
| 80310    | 1       |          |
| 82960    | 8       |          |

D3999-7 Manufactured No 100 Each 6.0000 1 1 H 13-01-15  
Corner

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 6       |          |
| 71695    | 1       |          |
| 86021    | 5       |          |

D3999-9 Manufactured No 100 Each 5.0000 1 1 H 13-01-11  
Angle

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 5       |          |
| 82545    | 1       |          |
| 86022    | 4       |          |

D3999-11 Manufactured No 100 Each 13.0000 1 1 H 13-01-15  
Earth Tab

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 13      |          |
| 84161    | 13      |          |

D4000-1 Manufactured No 100 Each 4.0000 1 1 H 13-01-15  
Fuel Supply Fitting

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 4       |          |
| 83811    | 4       |          |

D4000-5 Manufactured No 100 Each 2.0000 1 1 H 13-01-14  
Fuel Tank Vent Fitting

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 2       |          |
| 83813    | 2       |          |

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Shop Packet Print

Page 2

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped.             | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabeled                      |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

|                                   |              |    |                 |                |                 |   |              |                 |
|-----------------------------------|--------------|----|-----------------|----------------|-----------------|---|--------------|-----------------|
| D4000-9                           | Manufactured | No | 100             | Each           | 13.0000         | 3 | 3            | <i>13-01-14</i> |
| Grommet                           |              |    |                 |                |                 |   |              |                 |
|                                   |              |    | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |   |              |                 |
|                                   |              |    | WA003           | 13             |                 |   |              |                 |
|                                   |              |    | 83814           | 2              |                 |   |              |                 |
|                                   |              |    | 85907           | 11             |                 |   | <u>3</u>     |                 |
| D4000-045                         | Manufactured | No | 100             | Each           | 6.0000          | 1 | 1            | <i>13-01-22</i> |
| Fuel Pickup Fitting Assembly      |              |    |                 |                |                 |   |              |                 |
|                                   |              |    | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |   |              |                 |
|                                   |              |    | WA003           | 6              |                 |   |              |                 |
|                                   |              |    | 71669           | 1              |                 |   |              |                 |
|                                   |              |    | 72078           | 1              |                 |   |              |                 |
|                                   |              |    | 90582           | 4              |                 |   | <u>1</u>     |                 |
| D4008-11                          | Manufactured | No | 100             | Each           | 3.0000          | 1 | 1            | <i>13-01-11</i> |
| Hinge Half                        |              |    |                 |                |                 |   |              |                 |
|                                   |              |    | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |   |              |                 |
|                                   |              |    | WA003           | 3              |                 |   |              |                 |
|                                   |              |    | 80037           | 1              |                 |   |              |                 |
|                                   |              |    | 80838           | 2              |                 |   | <u>1</u>     |                 |
| D4008-041                         | Manufactured | No | 190             | Each           | 6.0000          | 1 | 1            | <i>73</i>       |
| Fuel Filler Splash Guard Assembly |              |    |                 |                |                 |   |              |                 |
|                                   |              |    | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |   |              |                 |
|                                   |              |    | ST142           | 6              |                 |   |              |                 |
|                                   |              |    | 84013           | 1              |                 |   |              |                 |
|                                   |              |    | 85041           | 5              |                 |   | <u>85041</u> |                 |
| D4023-3                           | Manufactured | No | 190             | Each           | 11.0000         | 1 | 1            | <i>13-01-11</i> |
| Cap and Flange                    |              |    |                 |                |                 |   |              |                 |
|                                   |              |    | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |   |              |                 |
|                                   |              |    | WA003           | 11             |                 |   |              |                 |
|                                   |              |    | 81898           | 3              |                 |   | <u>1</u>     |                 |
|                                   |              |    | 84422           | 8              |                 |   |              |                 |

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabelled                     |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

|                       |              |                 |                |      |                 |   |   |                    |
|-----------------------|--------------|-----------------|----------------|------|-----------------|---|---|--------------------|
| D4025-5               | Manufactured | No              | 190            | Each | 5.0000          | 1 | 1 | <i>JB 13-02-12</i> |
| Fuel Quantity Sender  |              |                 |                |      |                 |   |   |                    |
|                       |              | <u>Location</u> | <u>Loc Qty</u> |      | <u>Loc Code</u> |   |   |                    |
|                       |              | ST141           | 5              |      |                 |   |   |                    |
|                       |              | 81899           | 1              |      |                 |   |   |                    |
|                       |              | 84421           | 4              |      |                 |   |   |                    |
| D4057-1               | Manufactured | No              | 100            | Each | 10.0000         | 3 | 3 | <i>13-01-14</i>    |
| Retaining Ring        |              |                 |                |      |                 |   |   |                    |
|                       |              | <u>Location</u> | <u>Loc Qty</u> |      | <u>Loc Code</u> |   |   |                    |
|                       |              | WA003           | 10             |      |                 |   |   |                    |
|                       |              | 83656           | 10             |      |                 |   |   |                    |
| D4062-041             | Manufactured | No              | 190            | Each | 6.0000          | 1 | 1 | <i>13-01-11</i>    |
| Tank Support Assembly |              |                 |                |      |                 |   |   |                    |
|                       |              | <u>Location</u> | <u>Loc Qty</u> |      | <u>Loc Code</u> |   |   |                    |
|                       |              | WA003           | 6              |      |                 |   |   |                    |
|                       |              | 86024           | 6              |      |                 |   |   |                    |
| D4124-1               | Manufactured | No              | 100            | Each | 15.0000         | 4 | 4 | <i>13-01-15</i>    |
| Tab                   |              |                 |                |      |                 |   |   |                    |
|                       |              | <u>Location</u> | <u>Loc Qty</u> |      | <u>Loc Code</u> |   |   |                    |
|                       |              | WA003           | 15             |      |                 |   |   |                    |
|                       |              | 83824           | 1              |      |                 |   |   |                    |
|                       |              | 93815           | 14             |      |                 |   |   |                    |
| D4125-1               | Manufactured | No              | 100            | Each | 7.0000          | 1 | 1 | <i>13-01-11</i>    |
| Sump                  |              |                 |                |      |                 |   |   |                    |
|                       |              | <u>Location</u> | <u>Loc Qty</u> |      | <u>Loc Code</u> |   |   |                    |
|                       |              | ST150           | 5              |      |                 |   |   |                    |
|                       |              | 90234           | 5              |      |                 |   |   |                    |
|                       |              | WA003           | 2              |      |                 |   |   |                    |
|                       |              | 83825           | 1              |      |                 |   |   |                    |
|                       |              | 86060           | 1              |      |                 |   |   |                    |

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |             |             |            |   |                          |   |                        |                     |                     |  |  |
|--|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |             |             |            | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                        |                     |                     |  |  |
| <b>Root Cause</b>  | <b>Date</b> | <b>Step</b> | <b>Qty</b> | <b>Description of work order update or Non-conformance</b>  | <b>Initial Chief Eng</b> | <b>Action Description</b>   | <b>Sign &amp; Date</b> | <b>Verification</b> | <b>QC Inspector</b> |  |  |
| Doc/Data <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Equip/Tooling <input type="checkbox"/>                       |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Operator <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Material <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Setup <input type="checkbox"/>                               |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Other <input type="checkbox"/>                               |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Process <input type="checkbox"/>                             |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Supplier <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Training <input type="checkbox"/>                            |             |             |            |   |                          |   |                        |                     |                     |  |  |
| Unapproved <input type="checkbox"/>                          |             |             |            |   |                          |   |                        |                     |                     |  |  |

| FAULT CATEGORY   |   |   |   |
|--|---|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped.<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |



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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

|                          |              |                 |     |                |                 |   |          |             |
|--------------------------|--------------|-----------------|-----|----------------|-----------------|---|----------|-------------|
| D4125-3<br>End           | Manufactured | No              | 100 | Each           | 7.0000          | 1 | 1        | 13-01-11    |
|                          |              | <u>Location</u> |     | <u>Loc Qty</u> | <u>Loc Code</u> |   |          |             |
|                          |              | WA003           |     | 7              |                 |   |          |             |
|                          |              | 83826           |     | 1              |                 |   |          |             |
|                          |              | 86061           |     | 1              |                 |   | 1        |             |
|                          |              | 90235           |     | 5              |                 |   |          |             |
| D4404-3<br>Cushion, Side | Manufactured | No              | 100 | Each           | 1.0000          | 1 | 1        | JB          |
|                          |              | <u>Location</u> |     | <u>Loc Qty</u> | <u>Loc Code</u> |   |          |             |
|                          |              | ST143           |     | 1              |                 |   |          |             |
|                          |              | 88191           |     | 1              |                 |   | 88191    |             |
| D4404-5<br>Cushion, Fwd  | Manufactured | No              | 100 | Each           | 9.0000          | 4 | 4        | JB 13-02-12 |
|                          |              | <u>Location</u> |     | <u>Loc Qty</u> | <u>Loc Code</u> |   |          |             |
|                          |              | ST143           |     | 9              |                 |   |          |             |
|                          |              | 87501           |     | 3              |                 |   | 2x 87501 |             |
|                          |              | 90553           |     | 6              |                 |   | 2x 90553 |             |
| D4462-1<br>Baffle        | Manufactured | No              | 100 | Each           | 5.0000          | 1 | 1        | 13-01-14    |
|                          |              | <u>Location</u> |     | <u>Loc Qty</u> | <u>Loc Code</u> |   |          |             |
|                          |              | WA003           |     | 5              |                 |   |          |             |
|                          |              | 84353           |     | 2              |                 |   | 1        |             |
|                          |              | 89923           |     | 3              |                 |   |          |             |
| D4462-3<br>Baffle        | Manufactured | No              | 100 | Each           | 5.0000          | 1 | 1        | 13-01-14    |
|                          |              | <u>Location</u> |     | <u>Loc Qty</u> | <u>Loc Code</u> |   |          |             |
|                          |              | WA003           |     | 5              |                 |   |          |             |
|                          |              | 89924           |     | 5              |                 |   | 1        |             |

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |                                       |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|---------------------------------------|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |                                       |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |                                       |                                    |  |                                |                                    |                                    |                                   |  |
| Thermforming <input type="checkbox"/>                        | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |                                       |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |                                       |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause                             | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling <input type="checkbox"/> |      |      |     |   |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Setup <input type="checkbox"/>         |      |      |     |   |                   |                    |             |              |              |
| Other <input type="checkbox"/>         |      |      |     |   |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |   |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Unapproved <input type="checkbox"/>    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabel                        |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |

# Picklist Print

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

D4463-041 Tank Top Assembly Manufactured No 120 Each 8.0000 1 1 1/13.01.14

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 8       |          |
| 84364    | 4       |          |
| 92263    | 4       |          |

D4463-3 Tank Aft End Manufactured No 100 Each 6.0000 1 1 1/13.01.15

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 6       |          |
| 89919    | 6       |          |

D4463-5 Tank Upper Cut Out Manufactured No 100 Each 5.0000 1 1 1/13.01.15

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 5       |          |
| 76906    | 1       |          |
| 83834    | 4       |          |

D4463-7 Tank Fwd End Manufactured No 100 Each 5.0000 1 1 1/13.01.15

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 5       |          |
| 88564    | 1       |          |
| 89918    | 4       |          |

D4463-9 Tank Back Manufactured No 100 Each 6.0000 1 1 1/13.01.14

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003    | 6       |          |
| 89920    | 6       |          |

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# Picklist Print

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Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

D4463-11 Tank Front Manufactured No 100 Each 6.0000 1 1 *1/13-01-11*

| <u>Location</u>  | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| WA003            | 6              |                 |
| <del>88021</del> | 1              | <i>1</i>        |
| 89921            | 5              |                 |

D4463-13 Tank Bottom Manufactured No 190 Each 9.0000 1 1 *1/13-01-11*

| <u>Location</u>  | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| WA003            | 9              |                 |
| 82237            | 2              |                 |
| 83831            | 1              |                 |
| <del>86575</del> | 2              | <i>1</i>        |
| 89922            | 4              |                 |

AN3H5A Bolt Purchased No 190 Each 24.0000 5 5 *20*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u>  |
|-----------------|----------------|------------------|
| ST350           | 24             |                  |
| 120693          | 4              | <i>4x 120693</i> |
| 122800          | 20             | <i>1x 122800</i> |

MS21042L3 Nut Purchased No 190 Each 4,356.0000 4 4 *23 13-02-12*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001           | 38             |                 |
| 122141          | 38             |                 |
| GA              | 450            |                 |
| 122452          | 450            |                 |
| ST314           | 368            |                 |
| 117885          | 32             |                 |
| 119017          | 55             |                 |
| 119075          | 138            |                 |
| 123265          | 143            |                 |
| ST506           | 3500           |                 |
| 123900          | 3500           | <i>123900</i>   |

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# Picklist Print

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Page 8

Work Order ID: 95519

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

MS35206-266

Purchased

No

190

Each

174.0000

4

4

Screw

Location

Loc Qty

Loc Code

ST289

174

119850

74

123168

100

119850

NAS1149D0363J

Purchased

No

190

Each

1,554.0000

37

Washer

Location

Loc Qty

Loc Code

FP001

35

123248

35

GA

8

122378

8

ST294

1511

122378

913

123355

598

124392

AN3-4A

Purchased

No

190

Each

545.0000

24

24

Bolt

Location

Loc Qty

Loc Code

ST350

195

120308

80

122814

115

ST512

350

120770

200

123900

150

122814

D4577-1

Manufactured

No

190

Each

3.0000

1

1

Rear Access Panel

Location

Loc Qty

Loc Code

ST142

3

86085

3

86085

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# Picklist Print

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Work Order ID: 95519  
 Parent Item: D4464-041  
 Parent Item Name: Fuel Tank Assembly

Start Date: 1/10/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

D4577-3 Middle Access Panel Manufactured No 190 Each 3.0000

## Location

## Loc Qty

## Loc Code

WA003

3

86086

3

D4577-041 Fwd Access Panel Assembly Manufactured No 190 Each 1.0000

## Location

## Loc Qty

## Loc Code

ST237A

1

95275

1

13/02/14

13-02-12

95275

13/02/19

13/02/19

\*AN3-6A 4x M122814 13.02.19

\*NAS 1149DO 332 J 5x M122973 13.02.19

| ITEM NO. | QTY.<br>-041 | PART NUMBER   | DESCRIPTION                        |
|----------|--------------|---------------|------------------------------------|
| 1        | X            | D4464-041     | FUEL TANK ASSEMBLY                 |
| 2        | 2            | D3997-5       | PLACARD "AUX FUEL DRAIN"           |
| 3        | 1            | D3997-11      | PLACARD "LOADING"                  |
| 4        | 1            | D3997-17      | PLACARD "STOWAGE"                  |
| 5        | 1            | D3997-29      | PLACARD "WARNING"                  |
| 6        | 1            | D3997-43      | PLACARD "EARTH"                    |
| 7        | 1            | D3999-7       | CORNER                             |
| 8        | 1            | D3999-9       | ANGLE                              |
| 9        | 1            | D3999-11      | EARTH TAB                          |
| 10       | 1            | D4000-1       | FUEL SUPPLY FITTING                |
| 11       | 1            | D4000-5       | FUEL TANK VENT FITTING             |
| 12       | 3            | D4000-9       | GROMMET                            |
| 13       | 1            | D4000-045     | FUEL PICK UP AND STRAINER ASSEMBLY |
| 14       | 1            | D4008-11      | TANK HINGE HALF                    |
| 15       | 1            | D4008-041     | FUEL FILLER SPLASH GUARD ASSEMBLY  |
| 16       | 1            | D4023-3       | FUEL CAP                           |
| 17       | 1            | D4025-5       | FUEL SENDER                        |
| 18       | 3            | D4057-1       | RETAINING RING                     |
| 19       | 1            | D4062-041     | TANK SUPPORT ASSEMBLY              |
| 20       | 4            | D4124-1       | TAB                                |
| 21       | 1            | D4125-1       | FWD SEDIMENT BOWL                  |
| 22       | 1            | D4125-3       | AFT SEDIMENT BOWL                  |
| 23       | 1            | D4404-3       | CUSHION, SIDE                      |
| 24       | 4            | D4404-5       | CUSHION, FWD                       |
| 25       | 1            | D4462-1       | BAFFLE                             |
| 26       | 1            | D4462-3       | BAFFLE                             |
| 27       | 1            | D4463-041     | TOP TANK ASSEMBLY                  |
| 28       | 1            | D4463-3       | TANK AFT END                       |
| 29       | 1            | D4463-5       | TANK UPPER CUT OUT                 |
| 30       | 1            | D4463-7       | TANK FORWARD END                   |
| 31       | 1            | D4463-9       | TANK BACK                          |
| 32       | 1            | D4463-11      | TANK FRONT                         |
| 33       | 1            | D4463-13      | TANK BOTTOM                        |
| 34       | 1            | D4577-041     | FWD ACCESS PANEL ASSEMBLY          |
| 35       | 1            | D4577-1       | REAR ACCESS PANEL                  |
| 36       | 1            | D4577-3       | MIDDLE ACCESS PANEL                |
| 37       | 24           | AN3-4A        | BOLT                               |
| 38       | 5            | AN3H5A        | BOLT                               |
| 39       | 4            | MS21042L3     | NUT                                |
| 40       | 4            | MS35207-266   | SCREW                              |
| 41       | 37           | NAS1149D0363J | WASHER                             |

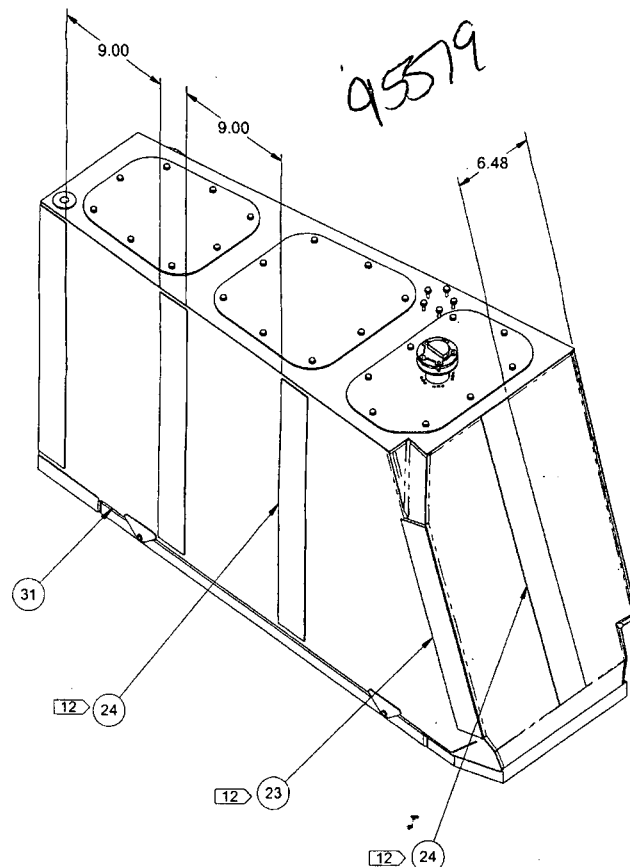
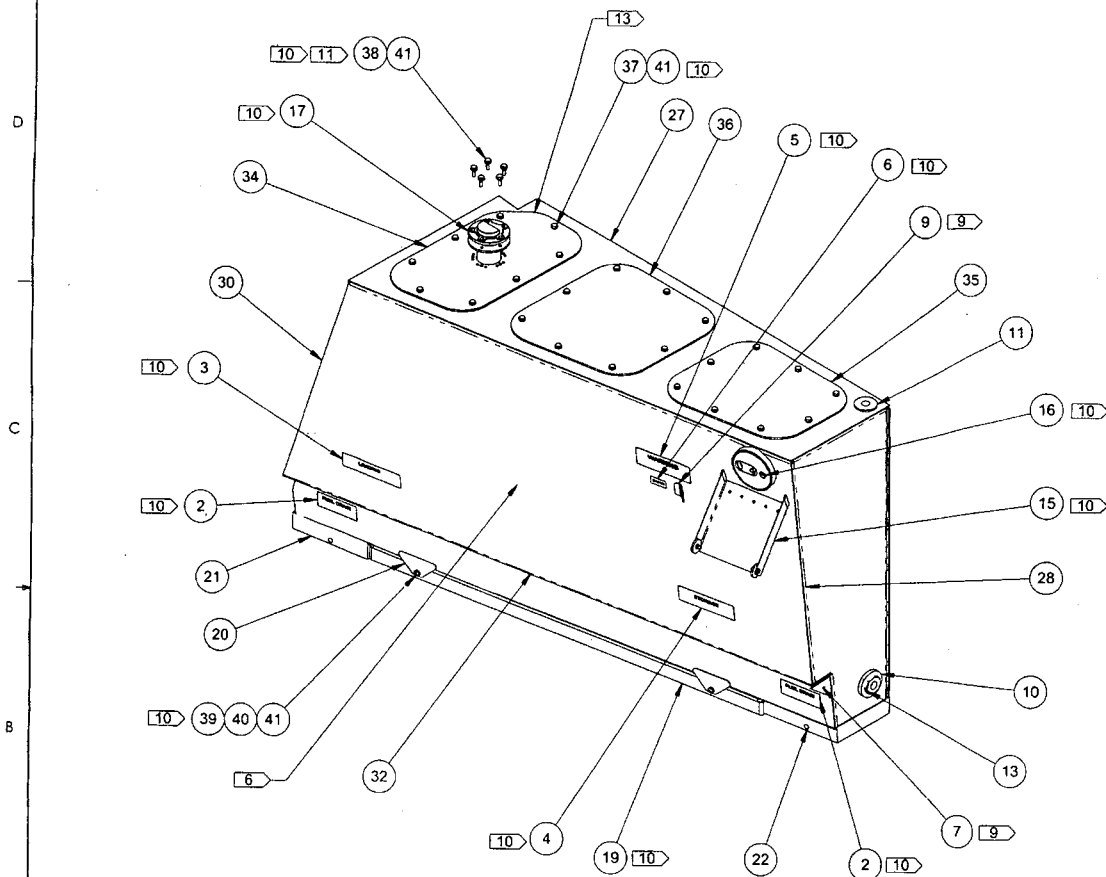
#95379

RELEASED  
R 2012-05-09

|            |   |  |          |
|------------|---|--|----------|
| D          | ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.  | DC   | 12.05.02 |
| C          | UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2. | DC   | 12.03.27 |
| B          | UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13, ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.                            | DC   | 11.12.14 |
| A          | NEW ISSUE, REF PAR11-117 & CAR 11-54.   | DC   | 11.10.19 |
| REV.       | DESCRIPTION   | BY   | DATE     |
| DESIGN     | BC  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D4464</b> REV. D<br>SHEET 1 OF 5<br>TITLE <b>TANK ASSEMBLY</b> SCALE NTS<br>COPYRIGHT © 2011 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |
| DRAWN      | BC  |  |          |
| CHECKED    | BC  |  |          |
| MFG. APPR. | BC  |  |          |
| APPROVED   | BC  |  |          |
| DE APPR.   | BC  |  |          |
| DATE       | 12.05.02  |  |          |



8 7 6 5 4 3 2 1



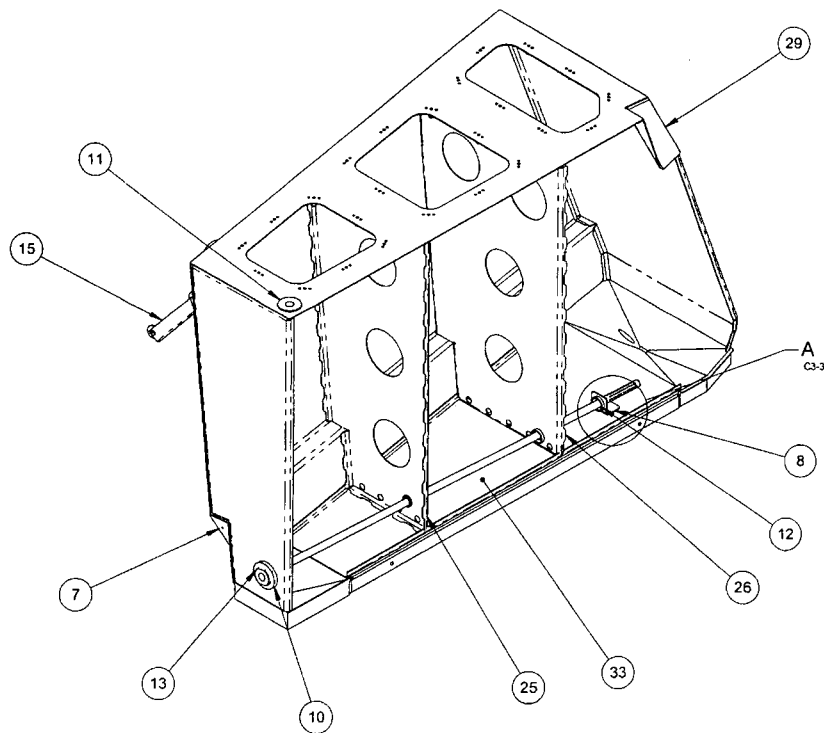
# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 35.81 lbs
- 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 9) MASK PRIOR TO POWDER COAT
- 10) INSTALL AFTER POWDER COAT
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-041/-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

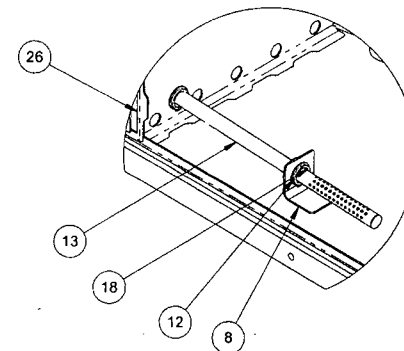
## **D4464-041 FUEL TANK ASSEMBLY**

**RELEASED**  
R 2012-05-09

|   |           |  |              |
|---|-----------|--|--------------|
| DESIGN  | <i>BC</i> | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | <i>BC</i> | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   | <i>BC</i> | DRAWING NO.                            | REV. D       |
| MFG. APPR.  | <i>BC</i> | <b>D4464</b>                           | SHEET 2 OF 5 |
| APPROVED  | <i>BC</i> | TITLE                                  | SCALE        |
| DE APPR.  | <i>BC</i> | <b>TANK ASSEMBLY</b>                   | NTS          |
| DATE  | 12.05.02  | COPYRIGHT © 2011 BY DART AEROSPACE LTD |              |
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**D4464-041 FUEL TANK ASSEMBLY**  
**D4463-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**

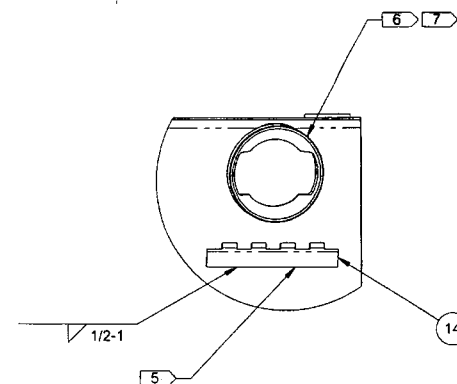
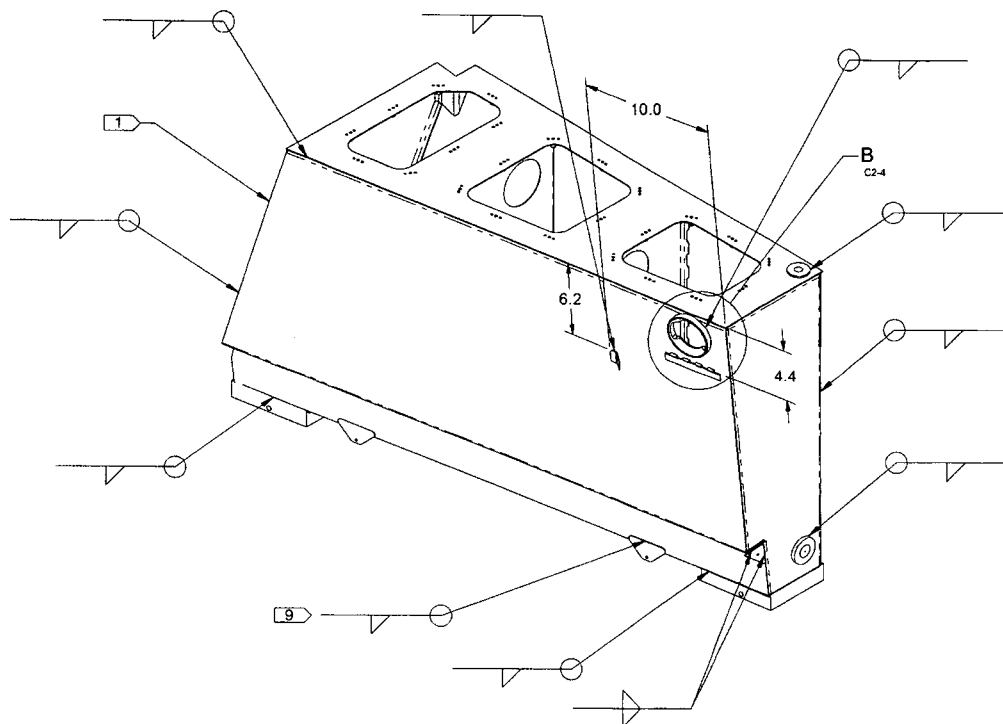


**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-3

**RELEASED**  
 2012-05-09  
*WMD*

|            |                 |  |        |
|------------|-----------------|--|--------|
| DESIGN     | <i>BC</i>       | <b>DART AEROSPACE LTD</b>  |        |
| DRAWN      | <i>BC</i>       | HAWKESBURY, ONTARIO, CANADA  |        |
| CHECKED    | <i>BC</i>       | DRAWING NO. <b>D4464</b>   | REV. D |
| MFG. APPR. | <i>BC</i>       | SHEET 3 OF 5   |        |
| APPROVED   | <i>BC</i>       | TITLE  | SCALE  |
| DE APPR.   | <i>BC</i>       | <b>TANK ASSEMBLY</b>   | NTS    |
| DATE       | <b>12.05.02</b> | COPYRIGHT © 2011 BY DART AEROSPACE LTD.<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |        |



**DETAIL B  
ROTATED FOR CLARITY  
SCALE 2X**

**RELEASED**  
2012-05-09

**D4464-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**

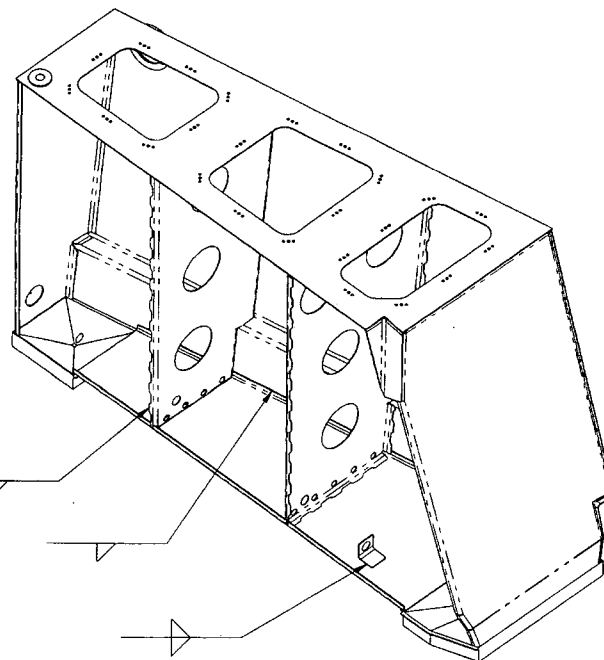
**NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED  
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL  
- ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING;  
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.

|            |           |   |        |
|------------|-----------|---|--------|
| DESIGN     | <i>BC</i> | <b>DART AEROSPACE LTD</b>   |        |
| DRAWN      | <i>BC</i> | HAWKESBURY, ONTARIO, CANADA   |        |
| CHECKED    | <i>BC</i> | DRAWING NO. <b>D4464</b>  | REV. D |
| MFG. APPR. | <i>BC</i> | SHEET 4 OF 5  |        |
| APPROVED   | <i>BC</i> | TITLE   | SCALE  |
| DE APPR.   | <i>BC</i> | <b>TANK ASSEMBLY</b>  | NTS    |
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95319

WELD ALL TABS



**D4464-041 FUEL TANK ASSEMBLY  
WELDING DETAIL**

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2012-05-09  
MR

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | JS       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | JS       |   |              |
| CHECKED    | JS       | DRAWING NO.   | REV. D       |
| MFG. APPR. | JS       | <b>D4464</b>  | SHEET 5 OF 5 |
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